

Work Order ID 92116

Tuesday, October 23, 2012 4:09:38 PM

92116

Page 1

Item ID: PB67-43001-17

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Aft Adjustable Blade Support Assembly

Start Date: 10/23/2012 Start Qty: 4.00 ***4***

Cust Item ID:

Required Date: 11/2/2012 Req'd Qty: 4.00 ***4***

Customer:

Reference:

Approvals: Process Plan: MLJ Date: 12-10-25 Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***
Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
B67-43001-17	Rev C

100 0.00

100

Large Fab

Large Fab

Memo

0.00

Large Fab

1- make a 0.090" chamfer in the 1.00" hole before welding

2- grind weld flush in area of PB67-43001-249 only

3- install helicol insert as per dwg

4- assemble parts and weld as per dwg

(4x) CC 12-12-6

110

QC9- Inspect visual per QSI004- Fusion Welds ✓ 0.00

110

QC

Memo

0.00

Quality Control

(4) 12-12-07 DAS 09 9-89

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Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

120 QC5- Inspect part completeness to step on W/O ✓ 0.00

120

QC Memo 0.00

Quality Control

④ 12-12-07



150 Chemical Conversion Coat per QSI005 4.1 0.00

150

HandFinish Memo 0.00

Hand Finishing

4 φ 12/12/10

160 Green Sandtex(Ref:4.3.5.8) per QSI005 4.3 0.00

160

Powdercoat Memo 0.00

Powder Coating

4X φ 12/12/11

1- MASK TUBE FROM BASE TO GUSSET START TIME: 8:45
OVEN TEMPERATURE: 320°F FINISH 9:20

M18144

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Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

170

QC3- Inspect Part Finish

0.00

170

QC

Memo

0.00

Quality Control

Handwritten signature

180

Small Fab

0.00

180

Small Fab

Memo

0.00

Small Fab

1- match drill cover to existing holes in support2- assemble as per dwg

DAS 24 12-12-12**4x**

190

QC5- Inspect part completeness to step on W/O

0.00

190

QC

Memo

0.00

Quality Control

DAS 16 12/17/12**4****DAS 23 12-12-12**

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Revision ID:

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Start Date: 10/23/2012 Start Qty: 4.00

4

Cust Item ID:

Required Date: 11/2/2012 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start ***NR1***

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

200

Identify as per dwg & Stock Location: *MA*

0.00

200

Packaging

Memo

0.00

Packaging

*4**Q**12.12.12*

210

QC21- Final Inspection - Work Order Release

0.00

210

QC

Memo

0.00

Quality Control

*12/12/13**12-12-12*

Picklist Print

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Page 1

Work Order ID: 92116

Parent Item: PB67-43001-17

Parent Item Name: Aft Adjustable Blade Support Assembly

Start Date: 10/23/2012

Required Date: 11/2/2012

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A 08-06-26 new issue DD verified by:ec
dwg EC verified by:DD

IPP Rev B 10.09.28 per rev C

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
PB67-43001-71 20° Blade Support Assembly		Manufactured	No				Each	1.0000		4		CC 12-12-6	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST437A		1		B 92085			(4X)		
				41512		1							
PB67-43001-249 Inner Tube Bushing		Manufactured	No			100	Each	3.0000	1	4		CC 12-12-6	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST438		3		B 90927			(4X)		
				52480		3							
PB67-43001-253 Gusset		Manufactured	No			100	Each	7.0000	1	4		CC 12-12-6	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA		7		B 90928			(4X)		
				85185		7							
PB67-43001-254 Gusset		Manufactured	No			100	Each	16.0000	1	4		CC 12-12-6	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST438		16		B 52481			(4X)		
				52481		16							
PB67-43001-259 Inner Tube		Manufactured	No			100	Each	1.0000	1	4		CC 12-12-6	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST209		1		B 92470			(4X)		
				44979		1							

Picklist Print

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Work Order ID: 92116

Parent Item: PB67-43001-17

Parent Item Name: Aft Adjustable Blade Support Assembly

Start Date: 10/23/2012

Required Date: 11/2/2012

Start Qty: 4.00

Required Qty: 4.00

MS124780 Purchased No 180 Each 82.0000 1 4 12.12.06
HELICAL INSERT

Location Loc Qty Loc Code

ST333 82
111064 82

MS27039-1-10

Screw

Purchased No 180 Each 416.0000 8

Location Loc Qty Loc Code

308 8
122441 8
GA 100
120449 100
ST291 5
120120 5
ST305 300
122815 300
ST308 3
122027 3

NAS1149D0316J

Washer

Purchased No 180 Each 400.0000 8

Location Loc Qty Loc Code

ST298 400
122151 400

4
32 m123522 11v
m122815 21x
8p

32
~~m123522 11v~~
~~m122815 21x~~
m123482 8p

Picklist Print

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Work Order ID: 92116

Parent Item: PB67-43001-17

Parent Item Name: Aft Adjustable Blade Support Assembly

Start Date: 10/23/2012

Required Date: 11/2/2012

Start Qty: 4.00

Required Qty: 4.00

NAS1149D0363J

Washer

Purchased No

180 Each 4,785.0000

8 SP 32 m/22378

Location

Loc Qty

Loc Code

ST294

1854

123248

1254

123355

600

ST297

2820

122378

2820

32

ST298

111

117601

61

119537

33

120308

17

PB67-43001-73

Manufactured No

180 Each 5.0000

1 4

Location

Loc Qty

Loc Code

ST437A

5

53305

5

SP 3920843x

PB67-43001-83

Manufactured No

180 Each 5.0000

1

Location

Loc Qty

Loc Code

ST444

5

53240

5

1x

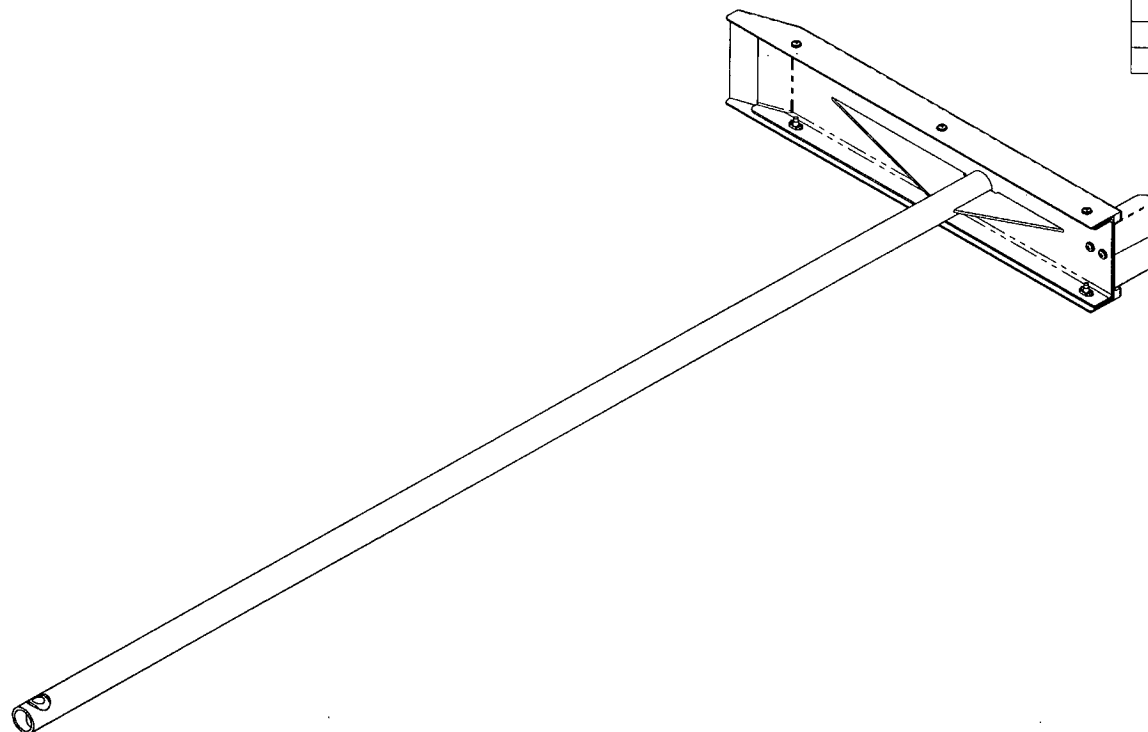
SP 12-12-7

3x90819 SP

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Shop Packet Print

Page 3



B67-43001-17 AFT ADJUSTABLE BLADE SUPPORT ASSY

ITEM	QTY -17	P/N	DESCRIPTION
1	X	B67-43001-17	AFT ADJUSTABLE BLADE SUPPORT ASSEMBLY
2	1	B67-43001-17W	AFT ADJUSTABLE BLADE SUPPORT WELDMENT
3	1	B67-43001-73	20° COVER PLATE
4	1	B67-43001-83	SHORT D-PAD ASSY
5	8	MS27039-1-10	SCREW
6	8	NAS1149D0316J	WASHER
7	6	NAS1149D0363J	WASHER

SHOP COPY
RETURN TO
UNCONTROLLED COPY
SUBJECT TO A FENDMENT
WITH A FENDMENT
V. C. C. OR C. R.

NO. 92116-MLS
12-10-25

RELEASED
2010-09-16

C	REDRAWN PREMIER AVIATION DRAWING IAW DART QSI 018 AND QSI 043. FOR PREVIOUS REVISIONS, REFER TO SHEET 7 OF PREMIER AVIATION DRAWING No. B67-43001. REASON: SEE PAR#09-011.		MB	10.04.28
REV.	DESCRIPTION		BY	DATE
DESIGN	RW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN		DRAWING NO.	REV. C	
CHECKED		B67-43001-17	SHEET 1 OF 2	
MFG. APPR.		TITLE	SCALE	
APPROVED		AFT ADJUSTABLE BLADE SUPPORT ASSY	NTS	
DE APPR.	N/A	DATE 10.04.28		
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8

7

6

5

4

3

2

1

92116

B67-43001-17W AFT ADJUSTABLE
BLADE SUPPORT WELDMENT
REF

NAS1149D0363J
WASHER

MS27039-1-10 SCREW [8]
NAS1149JD0316J WASHER

B67-43001-73
20° COVER PLATE
REF

SECTION A-A B7-2
SCALE 4X, 6 PL

B67-43001-73
20° COVER PLATE

B67-43001-17W AFT ADJUSTABLE
BLADE SUPPORT WELDMENT

MS27039-1-10 SCREW
NAS1149JD0316J WASHER
2 PL [8]

B67-43001-17 AFT ADJUSTABLE BLADE SUPPORT ASSY

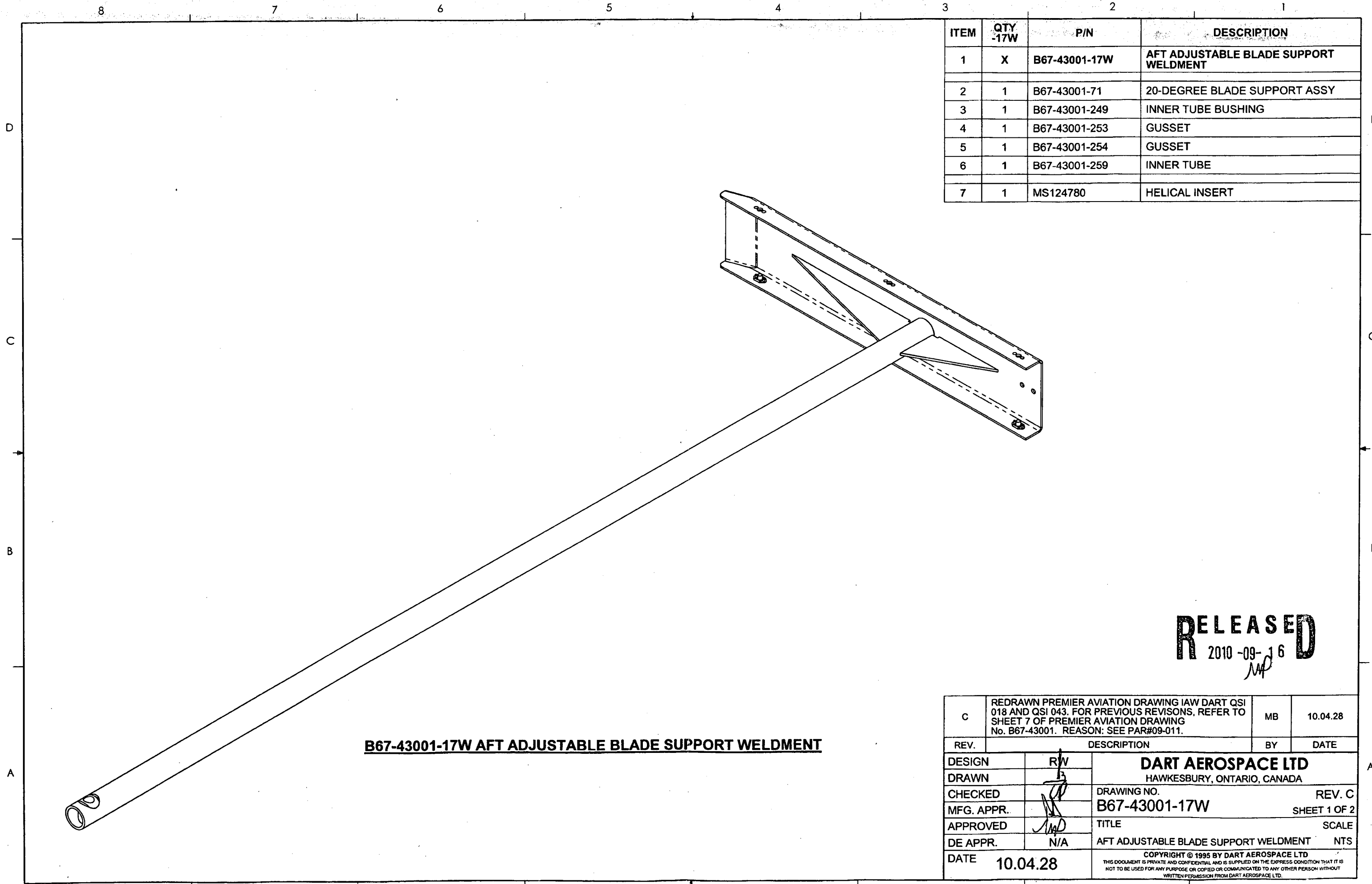
B67-43001-83
D-PAD ASSEMBLY, SHORT

RELEASED
2010-09-16

NOTES:

- 1) MATERIAL: NONE
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 9.09 lbs
- 8) LOCATE PARTS AS SHOWN AND TRANSFER DRILL $\phi 0.250$ TO $\phi 0.257$ HOLES FROM EXISTING HOLE PATTERNS ON B67-43001-17W AND B67-43001-83 TO B67-43001-73

DESIGN	RW	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		B67-43001-17	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.	N/A	AFT ADJUSTABLE BLADE SUPPORT ASSY	NTS
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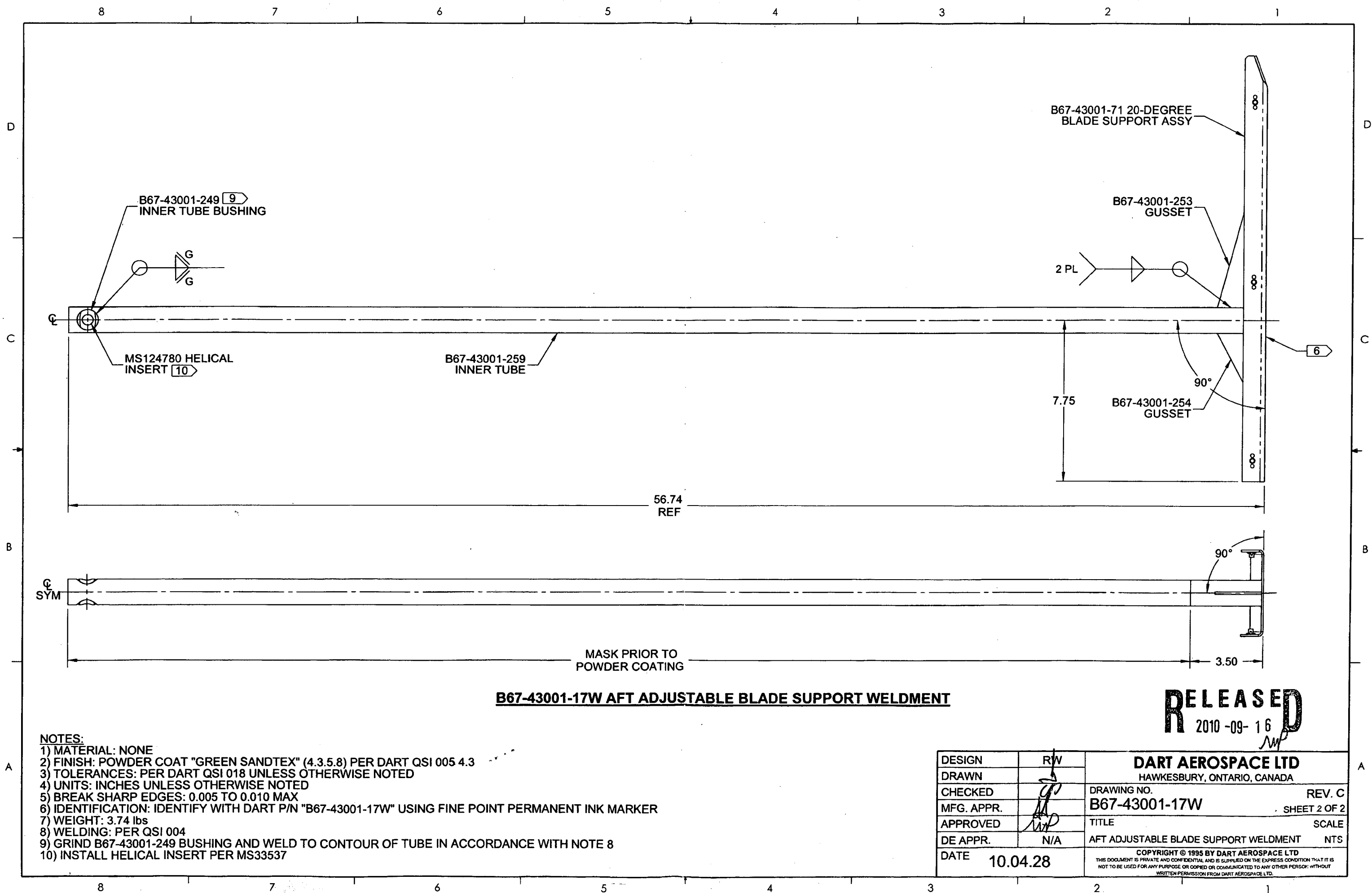


B67-43001-17W AFT ADJUSTABLE BLADE SUPPORT WELDMENT

ITEM	QTY -17W	P/N	DESCRIPTION
1	X	B67-43001-17W	AFT ADJUSTABLE BLADE SUPPORT WELDMENT
2	1	B67-43001-71	20-DEGREE BLADE SUPPORT ASSY
3	1	B67-43001-249	INNER TUBE BUSHING
4	1	B67-43001-253	GUSSET
5	1	B67-43001-254	GUSSET
6	1	B67-43001-259	INNER TUBE
7	1	MS124780	HELICAL INSERT

RELEASED
2010-09-16
MD

C	REDRAWN PREMIER AVIATION DRAWING IAW DART QSI 018 AND QSI 043. FOR PREVIOUS REVISIONS, REFER TO SHEET 7 OF PREMIER AVIATION DRAWING No. B67-43001. REASON: SEE PAR#09-011.	MB	10.04.28
REV.	DESCRIPTION	BY	DATE
DESIGN	RW	DART AEROSPACE LTD	
DRAWN	<i>[Signature]</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>[Signature]</i>	B67-43001-17W	SHEET 1 OF 2
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	N/A	AFT ADJUSTABLE BLADE SUPPORT WELDMENT	NTS
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B67-43001-17W AFT ADJUSTABLE BLADE SUPPORT WELDMENT

RELEASED
2010-09-16

- NOTES:**
- 1) MATERIAL: NONE
 - 2) FINISH: POWDER COAT "GREEN SANDTEX" (4.3.5.8) PER DART QSI 005 4.3
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "B67-43001-17W" USING FINE POINT PERMANENT INK MARKER
 - 7) WEIGHT: 3.74 lbs
 - 8) WELDING: PER QSI 004
 - 9) GRIND B67-43001-249 BUSHING AND WELD TO CONTOUR OF TUBE IN ACCORDANCE WITH NOTE 8
 - 10) INSTALL HELICAL INSERT PER MS33537

DESIGN	RW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		B67-43001-17W	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.	N/A	AFT ADJUSTABLE BLADE SUPPORT WELDMENT	NTS
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